

Work Order ID 55526

January 19, 2010 3:45:05 PM



Page 1

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/19/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *BA*

Date: 10-1-19

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3264

Rev A2

100

0.00



Bandsaw

Memo

0.00

amb 10/01/22

4 0

Jeaspa Bandsaw

CUT BLANK 5.700" LONG

110

0.00



HAAS 1

Memo

0.00

DJP 10/01/23

4

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA447

FOLIO REV: *44*

DWG REV: *44*

DEBURR AS PER DWG

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

DT 10/01/23

4

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SP 10/01/25

4

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

SP 10/01/25

(24) 0

Dart Aerospace Ltd

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Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

=> 11 10/01/26

(X4)

Ø

Memo

START: 7:00am

Temp: 320°F

FIN: 7:30am

0.00

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

PK 10-01-26

(4)

Ø

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: 144

0.00

0.00

10-1-27

(4)

Ø

Memo

W/O:		WORK ORDER CHANGES					
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Run Start

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Stop

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/27
MF
10-1-27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January 19, 2010 3:45:09 PM

Page 1

Work Order ID: 55526

Parent Item: D3264-1

Parent Item Name: Bracket

Comments: IPP A004.09.02 New issue: JKM/JLM

Start Date: 1/19/10

Required Date: 1/25/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No				f	47.8096	2.0000			



6061-T6 Bar 1.25 X 4.50



Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
MAT	47.8096	
105531	0.19	
108855	0.27	
109401	0.82	
111486	3.5296	
→ 112628	43	

2 on 10/01/22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55524
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.690	✓			
0.063	+/-0.010	0.062	✓			
0.125	+/-0.010	0.127	✓			
0.875	+0.010/-0.020	.877	✓			
0.062	+/-0.010	0.060	✓			
R0.03	+/-0.030	0.03	✓			
R0.13	+/-0.030	0.125	✓			
1.00	+/-0.030	1.003	✓			
0.125	+/-0.010	0.128	✓			
0.600	+/-0.010	0.599	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	0.750	✓			
Ø0.194	+0.005/-0.000	0.196	✓			
5.50	+/-0.030	5.503	✓			
0.125	+/-0.010	0.128	✓			
0.063	+/-0.010	0.064	✓			
R0.25	+/-0.030	0.250	✓			
4.27	+/-0.030	4.275	✓			
R0.30	+/-0.030	0.300	✓			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	10/01/23	Date:	10/01/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	<i>[Signature]</i>

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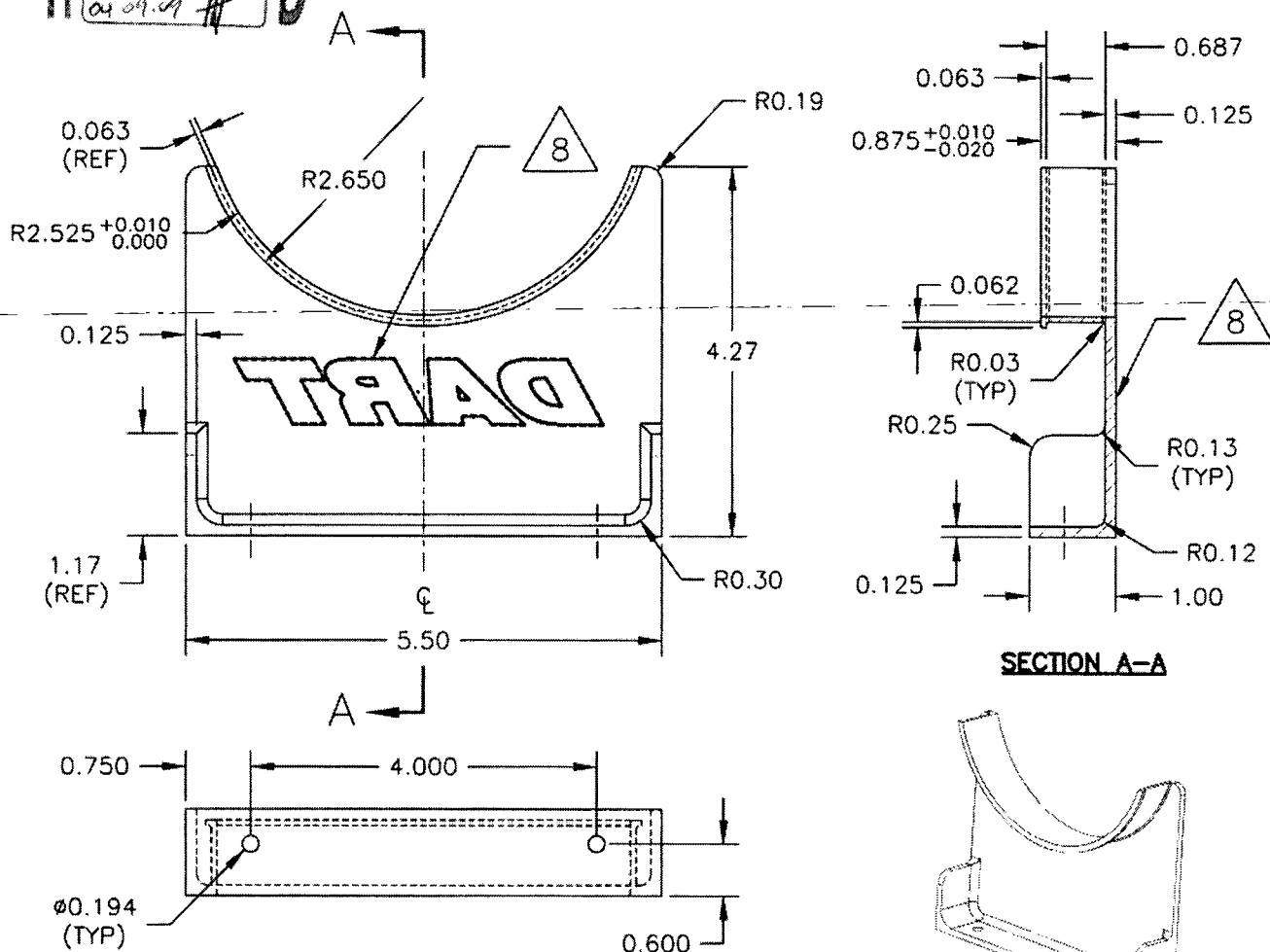


SUBJECT TO VERIFICATION AT
WITHOUT NOTICE
WORK ORDER
NO. 55526



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20	TITLE BRACKET		SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.09.09



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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